



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

DAS
69
9-89

C45-4-4KA
Job Sheet 192152



Part No: C45-4-4KA

Job Qty: 4 pcs

Part Name: Load Beam Keeperless Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/18/19

Job Tracking No:

Due Date: 4/26/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: C45-4-4KA rev.20 IPP REV:A 18.02.09 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Lead Time	Sign-off
					Setup Hrs	Run Hrs			
100	Small Fab - 1 <i>External Load</i>	4 pcs	4/26/19		0.00	0.27	Small Fab - 1	XLOAD - 1	AP 2019/03/25
							Small Fab - 2	XLOAD - 2	MICHAEL 2019/03/26
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
105	Conventional Mill - 1 - B4B <i>REWORK</i>	4 pcs	4/26/19		0.00	0.67	Conventional Mill - 1 B4B		
							Conventional Mill - 2 B4B		<i>APR 19-3-26</i>
110	QC 5 <i>CONV LAHLE 1 B4B</i>	4 pcs	4/26/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Outsource - 15 - Nickel Plate	4 pcs	4/26/19				GRO002-VC	10	APR 01 2019 <i>07/01/2019 PL</i>
140	Packaging 2-1 - Receive -	4	4/26/19		0.00	0.00	Packaging 2 - 1 - B4B		



Container No: S166226



Part: C45-4-4KA

Job No: 192152

Serial No/Batch: S166226

Revision: 20

Inspector:

Exp Date:

Instructions:

Date: 03/26/19

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

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B4B

pcs

				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DP APR 26 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
150 QC 6	4 pcs	4/26/19	0.00 0.00	QC 6 - 42	
				QC 6 - 9	
				QC 6 - 68	DAS APR 30 2019 68 9-89
				QC 6 - 61	
160 Packaging 3-2 - Stock - B4B	4 pcs	4/26/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS 28 9-89
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	

				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - FG	4	4/26/19	0.00 0.00	QC 21 - FG - 21	
	pcs			QC 21 - FG - 70	
				QC 21 - SA - 53	

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8-09

MAY 03 2019

Part Op 100 - Small Fab)ASSEMBLE AS PER DWG

Descriptions: 105 - (Manufacture as per dwg)

110 - (QC5- Inspect part completeness to step on W/O)

130 - -Issue P/O to Groupe Altech: P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade C -Nickel Plate

.0009-.0011 - Certificate of Conformity is required

140 - (Receive & Inspect for Damage & Mat'l Certs)

150 - (QC6- All purchased or subcontracted products)

160 - (Identify as per dwg & Stock Location: _____)

170 - QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
C45-4-2- PO	Trunnion, Load Beam	4 pcs (1 ea)	100-Small Fab - 1	5125611
C45-4-4K	C45 Load Beam Keeperless	4 pcs (1 ea)	100-Small Fab - 1	5047072

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	C45-4-2- PO	4	0	0
	C45-4-4K	4	11	0

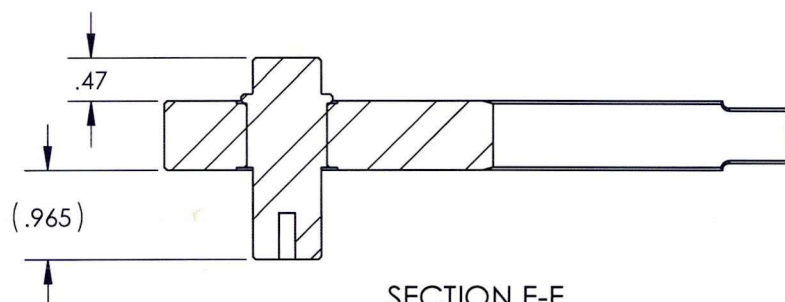
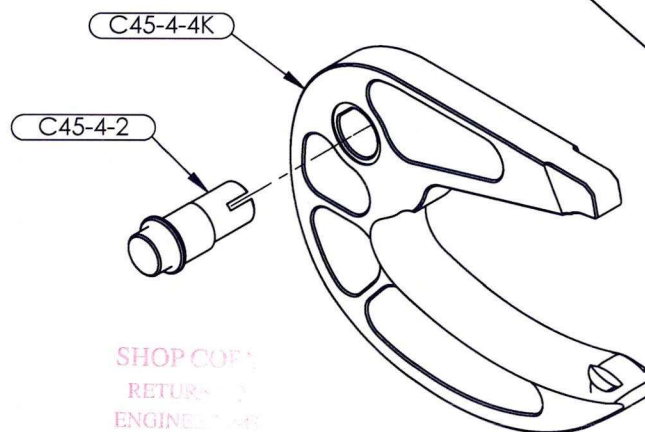
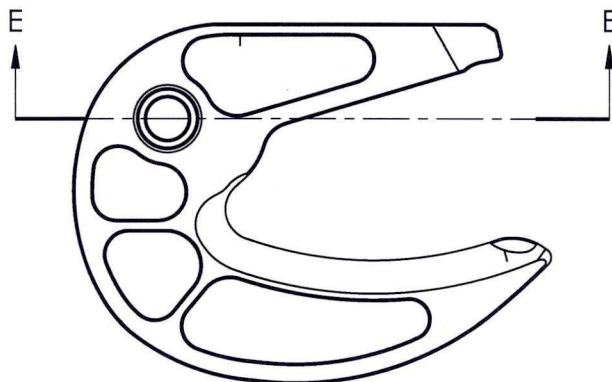
Part Specifications

Specifications could not be found.

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
19	15-0099	C45-4-4KA ADDED TO DRAWING FOR KEEPERLESS OPTION.	5/8/2015	RJC
				JAG



SECTION E-E
SCALE 1 : 2

C45-4-4KA

C45 LOAD BEAM KEEPERLESS ASSY.

SHOP COPY
RETURNS
ENGINEERING
UNCONTROLLED
SUBJECT TO
WITHOUT
WORK ORDER
NO. 192152ML5
1903-18

NOTE:
1. NICKEL PLATE .0009 - .0011, BAKE AFTER PLATING.

DART AEROSPACE	
TITLE C45 LOAD BEAM ASSEMBLIES	
DWG NO. C45-4-4A / C45-4-4KA	REV 20
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 06/05/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 06/06/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 06/14/2017	USED ON MODEL
APPROVED: JAG 06/15/2017	
SCALE 1:3	DATE 5/7/2015
SHEET 5 OF 6	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER

PO043048



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO043048

PO Date: 4/1/19

Due Date: 4/5/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	191779	C45-4-4A	C45 Load Beam Assembly Outsource15 (Outside Processing - Nickel Plate) -Issue P/O to Groupe Altech: P/O -Nickel plate, QQ-N-290, Class 2, Grade C -Nickel Plate .0009-.0011 - Certificate of Conformity is required	Firmed	-	4/5/19	7 pcs	0 pcs	7 pcs	\$24.50/pcs	\$171.50

Line/Item Note *** NEED BACK APRIL 05,2019 ***

2	192152	C45-4-4KA	Load Beam Keeperless Assembly -Issue P/O to Groupe Altech: P/O -Nickel plate, QQ-N-290, Class 2, Grade C -Nickel Plate .0009-.0011 - Certificate of Conformity is required	Firmed	-	4/5/19	4 pcs	0 pcs	4 pcs	\$15.20/pcs	\$60.80
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Line Item Note *** NEED BACK APRIL 05,2019 ***

Grand Total: \$232.30



Certificat de Conformité / Certificate of Compliance

(018136-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.grouupaltech.com

Bon de Livraison / Packing Slip

018136 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
03-Apr-2019		SPARTAKOS BOUNTOURIS		PO043048				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	C45-4-4A Rev.	C45-4-4A NICKLE PLATE, QQ-N-290 CLASS 2, GRADE C NICKLE PLATE .0009-.0011 01 - E-NIC STEEL 200 [E-NICKEL STEEL 200] 01 - E-NIC STEEL 200 [E-NICKEL STEEL 200] 01 - E-NIC STEEL 200 [E-NICKEL STEEL 200] 01 - E-NIC STEEL 200 [E-NICKEL STEEL 200]	E-NICKEL ALUM CH	7	7	0	0	0
2	C45-4-4KA Rev.	C45-4-4KA NICKLE PLATE, QQ-N-290 CLASS 2, GRADE C NICKLE PLATE .0009-.0011 01 - E-NIC STEEL 200 [E-NICKEL STEEL 200] 01 - E-NIC STEEL 200 [E-NICKEL STEEL 200] 01 - E-NIC STEEL 200 [E-NICKEL STEEL 200] 01 - E-NIC STEEL 200 [E-NICKEL STEEL 200]	E-NICKEL ALUM CH	4	4	0	0	0

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.



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PURCHASE ORDER

PO043048



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

A handwritten signature in black ink, appearing to be "Patrick Lussier", written over the bottom right of the Order Notes section.

Plex 4/2/19 1:38 PM dart.Lussier.Patrick